

Work Order ID 66768

Monday, February 28, 2011 7:46:36 AM

Page 1

Item ID: D3640-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Belt Guide

Start Date: 2/28/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-02-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3640

Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 4.700 " long

SL 11/03/07

(6)

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA670 & Dwg D3640 Rev: A
rad intersection with deburring tool.

2-Deburr and Blend

SL 11/03/09

(6)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66768

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Page 2

Item ID: D3640-1

Accept



Setup Start



Revision ID:

Item Name: Belt Guide

Stop



Start Date: 2/28/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		mr 11/03/10		6	0		
140 Packaging Packaging	Identify as per dwg & Stock Location <u>244</u> Memo	0.00 0.00							11/03/10 (6)
150 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/03/10 (6)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 28, 2011 7:46:42 AM

Page 1

Work Order ID: 66768



Parent Item: D3640-1



Parent Item Name: Belt Guide

Start Date: 2/28/2011

Required Date: 3/7/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-01-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRLNB0.75X1.250		Purchased	No			100	f	20.1639	0.4	2.526316			
										2.526316			
Delrin Bar													

Location

Loc Qty

Loc Code

MAT050

20.1639

14535

20.1639

2.53

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

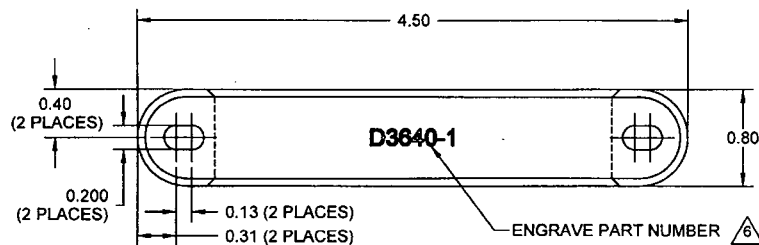
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

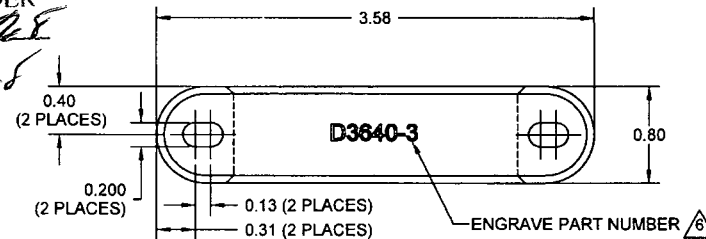
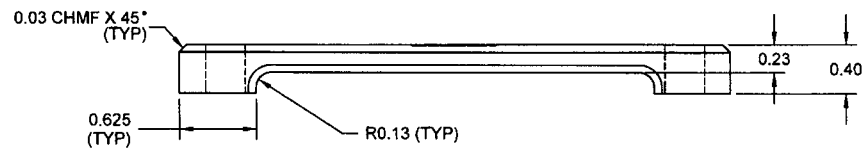
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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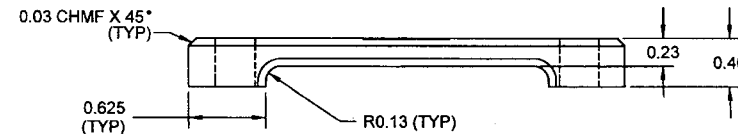
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66708
D11-02-25



D3640-1 BELT GUIDE
(WAS GENEVA P/N G10605-1)



D3640-3 BELT GUIDE
(WAS GENEVA P/N G10605-2)



- NOTES:
1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL BAR (REF DART SPEC M-DELIN-B)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBERS TO MAX DEPTH OF 0.010 AT LOCATIONS SHOWN
7) WEIGHT: 0.03 lbs



RELEASED
07.07.27

A	NEW ISSUE: REPLACES G10605		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC.		
DRAWN	LE	PORT HADLOCK, WA		
CHECKED	JS	DRAWING NO.	REV. A	
MFG. APPR.	JS	D3640	SHEET 1 OF 1	
APPROVED	JS	TITLE	SCALE	
DE APPR.	JS	BELT GUIDE	1:1	
DATE	07.07.27		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.	
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